



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ST 523
Gloss Black

D3910-3
Job Sheet 203503



Part No: D3910-3

Job Qty: 2 pcs

Part Name: Crosstube Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/19

Job Tracking No: Gloss Black

Due Date: 12/6/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV E SHEETS 1,3 IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP REV:C 18.02.02 REMOVE FINISH DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
140	Rework - 1 - Startup	2 pcs	12/6/19	12/6/19	0.00	0.20	Powdercoat - 1		
							Powdercoat - 2		BEB 19-11-29
							Powdercoat - 3		
							Powdercoat - 4		BK 19-12-6
150	Rework - 2 - B4B	2 pcs	12/6/19	12/6/19	0.00	0.00	QC 3 - 10		
							QC 3 - 13		
							QC 3 - 15		
							QC 3 - 17		
							QC 3 - 18		
							QC 3 - 2		
							QC 3 - 28		
							QC 3 - 3		
							QC 3 - 30		
							QC 3 - 34		
							QC 3 - 36		
							QC 3 - 41		
							QC 3 - 51		
							QC 3 - 58		
							QC 3 - 59		
							QC 3 - 68		
							QC 3 - 9		
							QC 3 - 40		6063 DEC 10 2019
							QC 3 - 19		
							QC 3 - 43		
							QC 3 - 24		
							QC 3 - 61		
							QC 3 - 81		
180	Packaging 3-1 - Stock - B4B	2 pcs	12/6/19	12/6/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

Plex 11/20/19 2:30 PM dart.lacelle.linda

DAS
81
9-89

DAS
74
9-89

DEC 1 2019

Packaging 3 - 4 - B4B	51523
Packaging 3 - 5 - B4B	
Packaging 3 - 6 - B4B	
Packaging 3 - 7 - B4B	
Packaging 3 - 8 - B4B	
Packaging 3 - 9 - B4B	
Packaging 3 - 10 - B4B	
Packaging 3 - 11 - B4B	
Packaging 3 - 12 - B4B	
Packaging 3 - 13 - B4B	
Packaging 3 - 14 - B4B	
Packaging 3 - 15 - B4B	
Packaging 3 - 16 - B4B	
Packaging 3 - 17 - B4B	
Packaging 3 - 18 - B4B	
Packaging 3 - 19 - B4B	
Packaging 3 - 20 - B4B	
Packaging 3 - 21 - B4B	
Packaging 3 - 22 - B4B	
Packaging 3 - 23 - B4B	
Packaging 3 - 24 - B4B	
Packaging 3 - 25 - B4B	
Packaging 3 - 26 - B4B	
Packaging 3 - 27 - B4B	
Packaging 3 - 28 - B4B	
Packaging 3 - 29 - B4B	
Packaging 3 - 30 - B4B	
Packaging 3 - 31 - B4B	
Packaging 3 - 32 - B4B	
Packaging 3 - 33 - B4B	
Packaging 3 - 34 - B4B	
Packaging 3 - 35 - B4B	
Packaging 3 - 36 - B4B	

190 QC 21 - SA 2 pcs 12/6/19 0.00 0.00

QC 21 - SA - 21

DAS

DEC 1 2 2019

QC 21 - SA - 70

21

QC 21 - SA - 53

2.00

Part Op 140 - Scuff and re powder coat Powder coat white gloss as per QSI005 4.3.5 START TIME: _____ OVEN
Descriptions: TEMPERATURE: _____ FINISH TIME: _____

150 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

M-4. 013240

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3910-3	Crosstube Lug	2 pcs (1 ea)	140-Rework - 1 - Startup	5204347

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
140-Rework - 1 - Startup	D3910-3	2	53	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Lug	4.450Inches $\pm$ 0.030	4.480 4.420		
2	Crosstube Lug	1.380Inches $\pm$ 0.030	1.410 1.350		
3	Crosstube Lug	0.080Inches $\pm$ 0.020	0.100 0.060	Radius	
4	Crosstube Lug	0.270Inches $\pm$ 0.030	0.300 0.240	reference	
5	Crosstube Lug	0.310Inches $\pm$ 0.030	0.340 0.280		
6	Crosstube Lug	0.735Inches $\pm$ 0.010	0.745 0.725	reference	
7	Crosstube Lug	1.200Inches $\pm$ 0.030	1.230 1.170	Radius	
8	Crosstube Lug	3.700Inches $\pm$ 0.010	3.710 3.690		
9	Crosstube Lug	0.375Inches $\pm$ 0.010	0.385 0.365		
10	Crosstube Lug	0.625Inches $\pm$ 0.010	0.635 0.615		
11	Crosstube Lug	0.375Inches $\pm$ 0.010	0.385 0.365		
12	Crosstube Lug	0.340Inches $\pm$ 0.030	0.370 0.310	Radius	
13	Crosstube Lug	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
14	Crosstube Lug	0.100Inches $\pm$ 0.010	0.110 0.090		
15	Crosstube Lug	45.000Degrees $\pm$ 0.500	45.500 44.500	angle	
16	Crosstube Lug	1.410Inches $\pm$ 0.030	1.440 1.380	Reference	

Plex 11/20/19 2:30 PM dart.lacelle.linda

DART
AEROSPACE

1270 Aberdeen Street
Hewkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S236224



Part: D3910-3

Job No: 203503

Serial No/Batch: S236224

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/29/19